Quality Control



Page 1

April-18-13 1:23:51 PM Item ID: D3913-041 Accept \*N900040100\* Setup Start **Revision ID:** Item Name: Long Basket Base Assemby, 350 Start Date: 4/18/13 Start Qty: 1.00 **Cust Item ID:** Required Date: 5/02/13 Req'd Qty: 1.00 **Customer:** Reference: Run Start Process Plan: MCJ Date: 1304-18 Tooling: Approvals: Date: \_\_\_ Stop SPC (Y/N): Date: Date: Sequence ID/ Operation Set Up/ **Tool ID** Tool # Plan Accept Reject Reject Insp. Work Center ID **Description Run Hours** Code Qty Number Qty Stamp Draw Nbr **Revision Nbr** D3913 В D4020 Α 100 Weld per dwg A/R S.S. rod Batch: 4/22 35 0.00 SH 13.05.07\_ Large Fab \*100\* Large Fab 0.00 Memo Large Fab 1- assemble ribs, weld as per dwg D3913 using DT9610A \*\*\*inspect before welding mesh\*\*\* 2-Cut D4020-1 base mesh and tack weld all mesh on basket as per dwg D3913 and trim mesh to fit if necessary and trim to clear fasteners holes on the ends 3- weld hinge (3) and Mounting brackets as per dwg D3913 \*\*\*take lid to locate hinge and bracket\*\*\* 4- Weld D4672-1 blanking plates as per dwg 110 QC9- Inspect visual per QSI004- Fusion Welds 0.00 \*110\* QC 0.00 Memo

NCR: Y	es / No				WC	RK ORDER NON-C	O	<b>NFORM</b>	MANCE / UP	DATE			
	•										QA Closed:	Date:	
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Part N	lo					Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
						Use-as-is	1	Therm	noforming	Finishing	Rec/Stor	e/Packaging	Other
NCR N	lo				,	Work Order Update			Large Fab	Composite		Supplier	
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Cause	Date	Step	Qty		or Non	-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
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	Cracks				Broke	en/Damaged		Inspect	ion Incomplete		Part Incorre	<del></del>	Weld
	Crushed/	Crimped			Burrs		L	instruct	tions Incomplete	/Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Conta	mination	L	Mainte	enance		Part Moved		
	Heat Trea	at			Coun	tersink		Mislabe	eled		Positioned \	Wrong	<del>-</del>
	Inspectio	n Strip in	1 Tube		Cut to	oo Short		Misread	d		Power Loss/	'Surge	Other
	Ripples in Bend Drill Holes						Offset						
	Torque Waves in Extrusion Drawing						Out of (	Calibration					
	Turning Sequence Finish					Out of Sequence							

Outside Dimensions

DQA:

Date:

Wave/Twist in Tube

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Insp.

Stamp

#### Work Order ID 100170 \*100170\* April-18-13 1:23:51 PM Item ID: D3913-041 Accept \*N900040100\* Setup Start **Revision ID:** Item Name: Long Basket Base Assemby, 350 Start Date: 4/18/13 Start Oty: 1.00 **Cust Item ID:** Required Date: 5/02/13 Req'd Qty: 1.00 **Customer:** Reference: Run Approvals: Process Plan: Date: Tooling: Date: Stop QC: \_\_\_\_\_ Date: \_\_\_\_ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Work Center ID **Description Run Hours** Code Qty Qty Number 130 White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel 0.00 \*130\* Powdercoat

0.00

m125069

Powder Coating

IST COAT: START TIME: OVEN TEMPERATURE: 2ND COAT: START TIME: OVEN TEMPERATURE: FINISH TIME

1- Plug holes and mask only interior of hinge (3) prior to powder

140

QC3- Inspect Part Finish

0.00

\*140\*

QC

Quality Control

Memo

Memo

0.00

NCR: Y	es /	No				W	RK ORDER NON-C	COP	NFORN	AANCE / UPI	DATE	QA Closed:	D	ate:	
Work Orde	er:			, , , , , , , , , , , , , , , , , , ,			DISPOSITION				_	 PARTMENT/	PROCESS		
Part N	-						Rework Scrap Use-as-is		Therm	Skid-tube Machining noforming	Crosstube Small Fab Finishing Composite		Water Je d. Eng. Coor e/Packagin Supplie	.	Engineering Quality Other
NCR N	No						Work Order Update	ال		Large Fab	Composite		Supplie	'ا	
Root Cause	D	ate	Step	Qty			of work order update -conformance	1	nitial iief Eng		tion ription	Sign & Date	Verificati	on	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved											· · · · · · · · · · · · · · · · · · ·				
111							General	AUL	T CATE	JORY		 			
Landi	Cer Cra Cru Cuf Hea	nding ntre Not cks shed/C fs at Treat pection	rimped. Strip in		//S	Brok Burrs Cont Cour	d 1/Route en/Damaged amination ntersink Too Short		Instruct Mainte Mislabe Misreac	ion Incomplete ions Incomplete/ enance eled	Unclear	 Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct ssing Vrong		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	⊢ '	ples in I		Sytrusion	_	Drill	Holes	-	Offset	Calibration					

Out of Sequence

Outside Dimensions

DQA: \_\_\_\_\_ Date: \_\_

Turning Sequence

Wave/Twist in Tube

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

1 6 41358

# Work Order ID 100170

April-18-13 1:23:51 PM

\*170\*
Packaging

Packaging

\*100170\*

Item ID: D3913-041 Accept \*N900040100\* Setup Start **Revision ID:** Item Name: Long Basket Base Assemby, 350 **Start Date:** 4/18/13 Start Oty: 1.00 Cust Item ID: Required Date: 5/02/13 Req'd Qty: 1.00 **Customer:** Reference: Run Process Plan: \_\_\_\_\_ Date: \_\_\_\_ Tooling: Approvals: Date: Stop \_\_\_\_\_ Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Accept Reject Insp. Work Center ID Description **Run Hours** Code Qty Qty Number Stamp 150 Assemble as per dwg 0.00 \*150\* HandFinish 0.00 Memo Hand Finishing Pick Kit 160 QC5- Inspect part completeness to step on W/O \*160\* QC 0.00 Memo Quality Control 100162 Identify as per dwg & Stock Location: D4630-00/10 170

0.00

Memo

									DQA:	Date	:
NCR: Y	es / No	)		wo	RK ORDER NON-C	CONFOR	MANCE / UPI	DATE	•		
									QA Closed:	Date	
Work Orde	or:				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
·				<del></del>	Rework	] [	Skid-tube	Crosstube		Water Jet	Engineering
Part N	lo.				Scrap		Machining	Small Fab	4	d. Eng. Coor.	Quality
					Use-as-is	Ther	moforming	Rec/Stor	re/Packaging	Other	
NCR N	lo			\ \	Work Order Update	]	Large Fab	Composite		Supplier	
Root				Description o	f work order update	Initial	1	tion	Sign &		
Cause	Date	Step	Qty	or Non-	conformance	Chief Eng	Descr	ription	Date	Verification	QC Inspector
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		Not Conce	entric to t	·	/Route	Hardw	tion Incomplete	<del> </del>	Part Incorre	<del> </del>	Weld
	Cracks	ما (۲۰۰۱)		Burrs	en/Damaged		ctions Incomplete/I	Unclear	Part Lost/M	<b>├</b>	Wrong Stock Pulled
	Cuffs	d/Crimped	-	1	mination	<del></del>	enance	Officieal	Part Moved	-	
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	—	reat tion Strip ir	Tube	<b>  </b>	oo Short	Misrea			Power Loss/		Other
		in Bend	i iube	Drill		Offset		<u> </u>	٦٠ - ١٠٠ - ١٠٠٠ - ١٠٠ - ١٠٠٠ - ١٠٠ - ١٠٠ - ١٠٠٠ - ١	· G	
		Waves in	Extrusio	<b>├</b> ─┤		<del></del>	Calibration				
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		Twist in Tu		Folio		Outside Dimensions					

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

# Work Order ID 100170 14 15 18-13 1:23:51 PM

\*100170\*

Item ID: Revision ID: Item Name:	D3913-041 Long Basket	Base Assemby. 350		Accept	*N900	040	100	)* ፡	Setup	Start Stop	*N.S	) !
Start Date: Required Date Reference:	4/18/13 : 5/02/13	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:	•				IVI.	
Approvals:	Process P	lan:	Date:	Tooling: SPC (Y/N):		ate:		I	Run	Start Stop	*NF	R1* R2*
Sequence ID/ Work Center II 180 *1 R \ * QC Quality Control	D	Operation Description QC21- Final Inspection - Memo	Work Order Release	Set Up/ Run Hours 0.00	Tool ID	Tool#	Code	Accept Qty	Qty	1	Number 3	Insp. Stamp OF 3 OF-09

NCR:	⁄es	/ No				WOR	RK ORDER NON-C	CON	NFORN	MANCE / UPI	DATE	QA Closed:	Date:	
Work Ords	~ · ·			· · · · · · · · · · · · · · · · · · ·			DISPOSITION			AAA	AGAINST DE	PARTMENT	PROCESS	
Work Orde	-						Rework Scrap Use-as-is		Therm	Skid-tube Machining noforming	Crosstube Small Fab Finishing		Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR 1	No.	<del></del> .		······		W	ork Order Update			Large Fab	Composite		Supplier	
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Cause		Date	Step	Qty	(	or Non-c	onformance	Ch	ief Eng	Desci	ription	Date	Verification	QC Inspector
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Landi	_				<u></u>	ا، ۵۰	General		Grain		_	Ovalized		Pressure/Forced
A.	-	Bending			o/s	Bend BOM/R	lauta.	-	Hardwa		-	Over/Under	tolerance	Temperature/Cure
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	$\vdash$	Cracks	Crimpod			Burrs	/Damageu	$\vdash$	1	ions Incomplete/	<u> </u>	Part Lost/M	<u> </u>	Wrong Stock Pulled
1	-	Crushed/ Cuffs	Crimpea.		-	Contam	ination	$\vdash$	Mainte	•	Officient	Part Moved	L_	
		Heat Trea	ıt.		-	Counte		$\vdash$	Mislabe	•		Positioned \	Wrong	
	-	Inspectio		Tube	-	Cut Too			Misread			Power Loss/		Other
		Ripples in		· unc	$\vdash$	Drill Ho			Offset		<u></u>	۱		
	$\vdash$			xtrusio	, <b> </b>	Drawin			4	Calibration		·		
	Н	Torque Waves in Extrusion Drawing Turning Sequence Finish				Out of Sequence								

Outside Dimensions

Date: \_\_\_

DQA:

Wave/Twist in Tube

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

# **Picklist Print**

April-18-13 1:23:55 PM

Work Order ID: 100170

\*100170\*

Parent Item:

D3913-041

\*D3913-041\*

Parent Item Name: Long Basket Base Assemby. 350

**Start Date:** 4/18/13

Required Date: 5/02/13

Start Qty: 1.00

Required Qty: 1.00

**Comments:** 

IPP Rev:A new issue DD 10.03.19 verified by:EC

chg qty's DD 10.04.12 verified b

AS PER DWG REV.B DD VERF:EC

.19 verified by:EC	IPP Rev:B
by:EC	IPP REV:C 12.07.24
F·FC	

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty p	er Kit	Total Qty	Qty Issued	Date Issued	Status
D2581		Manufactured	No			100	Each	72.0000		2	2			
*D2581* Mounting Bracket									**			503 <del>&gt;</del>	Jx_	W13.
				Location		Loc (	<u>Oty</u>	Loc Code						
				WA			44					•		
					98503		44					_		
				WA004			28					_		
					70766		2					_		
					81253		1			_		_		
					82506		2					<del></del>		
					83230		3					_		
					85452		2			_		_		
					87706		2					_		•
2012 1					98108		16			_	<del>_</del> .	_		
3913-1		Manufactured	No			100	Each	4.0000		1	1		. 1	
*D3913-1*									**	B	886	37 X	DS 13	3·05·E
				Location		Loc C	<u>Oty</u>	Loc Code						
				WA005			4							

<u>Location</u>	Loc Qty	Loc Code	
WA005	4		
87543	1		
94826	. 3	•	<del></del>

NCR: Y	es /	' No				wo	RK ORDER NON-C	ON	<b>VFORM</b>	MANCE / UPI	DATE					
						*							QA Closed:	Da	ate:	N. C. Commission of the Commis
Work Orde	or.						DISPOSITION				AGAINST D	EF	PARTMENT/	PROCESS		. ·
							Rework Scrap			Skid-tube Machining	Crosstube Small Fab		Prod	Water Jed d. Eng. Coor	$\vdash$	Engineering Quality
NCR N			,			V	Use-as-is Work Order Update			noforming Large Fab	Finishing Composite		Rec/Stor	e/Packaging Supplie	-	Other
Root Cause		Date	Step	Qty		•	work order update conformance	1	nitial ief Eng	Act Descr	ion iption		Sign & Datè	Verification	on	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved		3														
				<u> </u>			F	AUL	T CATE	GORY						
Landi			<del></del>			70	General				Г		Ovalized			Pressure/Forced
	c	racks	ot Concei Crimped		o/s	Broke Burrs	Route n/Damaged mination		ł '	ion Incomplete ions Incomplete/U	Jnclear		Over/Under Part Incorred Part Lost/Mi Part Moved	ct		Temperature/Cure Weld Wrong Stock Pulled
	H	eat Trea	n Strip in	Tube		Count	ersink o Short		Mislabe Misread Offset	eled			Positioned V Power Loss/	-		Other
Torque Waves in Extrusion Drawing					Out of Calibration											

Out of Sequence

Outside Dimensions

DQA: Date:

Turning Sequence

Wave/Twist in Tube

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

### **Picklist Print**

April-18-13 1:23:55 PM

Work Order ID: 100170

\*100170\*

Parent Item:

D3913-041

\*D3913-041\*

Parent Item Name: Long Basket Base Assemby. 350

**Start Date: 4/18/13** 

Required Date: 5/02/13

Start Qty: 1.00

Required Qty: 1.00

D3913-15

Manufactured

100

Each 13.0000

B100417 Sy 13.05.06

Wide Handle Plate

Location Loc Qty Loc Code WA004 13 90084 94153 97719

D3913-3

D3913-7

Manufactured

Manufactured

No

100

Each

7.0000

B97728 SS 130506

\*D3913-3\*

Location	Loc	<u>Qty</u>	Loc Code
WA004		3	
94825		3	
WA005		4	
69160		1	
84651		1	
94165		2	
	100	Each	7.0000

Location WA005 88492

Loc Oty

7

Loc Code

April-18-13 1:23:55 PM

**Shop Packet Print** 

Page 2

													DQA:	Date	e:	
NCR: \	Yes	/ No				WOF	RK ORDER NON-C	ON	NFORN	MANCE / UPE	DATE		QA Closed:	Date	e:	
			-	····· sp.			DISPOSITION	,-			AGAINS	· · · · · · · · · · · · · · · · · · ·	PARTMENT			
Work Orde	er: _				<del></del> -			,		crists to T	Crosstub			Water Jet	$\neg$	Engineering
Part N	۷o						Rework Scrap Use-as-is		ľ	Skid-tube Machining noforming	Small Fa Finishir	b		d. Eng. Coor. re/Packaging		Quality Other
NCR N	No			· · · · · ·	• • • •	W	ork Order Update			Large Fab	Composit	:e		Supplier		
Root					Descri	ption of	work order update	I	nitial	Act	ion	,	Sign &			
Cause	ŀ	Date	Step	Qty	(	or Non-q	onformance	Ch	ief Eng	Descr	ription		Date	Verification		QC Inspector
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		Bending				Bend			Grain			<u> </u>	Ovalized	}		Pressure/Forced
	Ш	Centre No	ot Concei	ntric to (	D/S	BOM/F		_	Hardwa			_	Over/Under	}	_	Temperature/Cure
		Cracks				Broken	/Damaged		1 '	ion Incomplete		<u> </u>	Part Incorre			Weld
	Ш	Crushed/	Crimped.			Burrs		_	4	ions Incomplete/l	Unclear	<u> </u>	Part Lost/M	issing	\	Wrong Stock Pulled
		Cuffs ·				Contam	ination		Mainte			<u> </u>	Part Moved			
		Heat Trea	it			Counte	ersink		Mislabe			<u> </u>	Positioned \	· · · · · · · · · · · · · · · · · · ·		
1		Inspection	n Strip in	Tube		Cut Too	Short	L	Misread	t			Power Loss/	'Surge	(	Other
		Ripples in	Bend			Drill Ho	oles	Offset								

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

April-18-13 1:23:55 PM

Work Order 1D: 100170

D3913-041

\*100170\* \*D3913-041\*

Parent Item Name: Long Basket Base Assemby. 350

**Start Date: 4/18/13** 

Required Date: 5/02/13

Start Qty: 1.00

Required Qty: 1.00

D3913-9

Parent Item:

Manufactured

Manufactured

Manufactured

100

Each

12.0000

\*D3913-9\* Hinge Rib

<b>Location</b>	Loc Qty	Loc Code
WA	1	
94814	ı	
WA005	11	
70138	1	
88215	1	
97674	9	
	100 E	ach 8.0000

\*D3916-041\*

Rib Assembly

D3916-041

Location	Loc Qty	Loc Code
WA004	6	
94818	6	
WA005	2	
81444	2	

\*D3916-5\*

Light Rib

D3916-5

Location Loc Qty Loc Code WA004 94163 94698

100

Each

14.0000

\*\*

WA005

77142 82933

NCR: Ye	es / No				WOR	K ORDER NON-C	CONI	ORN	MANCE / UPC	DATE	C	- QA Closed:	Date	o:	
Work Order	:					DISPOSITION				,	DEP	ARTMENT/	PROCESS		
Part No.						Rework Scrap Use-as-is		ı	Skid-tube Machining noforming	Crosstube Small Fab Finishing			Water Jet d. Eng. Coor. e/Packaging	Engineering Quality Other	
NCR No	NCR No.			<del></del>	Wo	ork Order Update			Large Fab	Composite	_	,	Supplier		
Root				Descri	otion of v	work order update	lni	tial	Act	ion		Sign &			
Cause	Date	Step	Qty	C	r Non-co	onformance	Chie	f Eng	Descr	ription		Date	Verification	QC Inspector	
Doc/Data															ŀ
Equip/Tooling												ļ			
Operator		1													
Material								į							
Setup		l													
Other															
Process			-												
Supplier														İ	
Training															
Unapproved															
		~				F	AULT	CATE	GORY			<del></del>			
Landin	g Gear				.	General							_	_	
	Bending				Bend			irain				Ovalized	_	Pressure/Forced	
	Centre No	ot Conce	ntric to O/	s	BOM/Ro	oute	Шн	lardwa	re			Over/Under	tolerance	Temperature/Cure	
	Cracks				Broken/	'Damaged	Lltr	rspecti	on incomplete		F	Part Incorred	ct	Weld	
	Crushed/	Crimped.			Burrs		l lr	nstruct	ions Incomplete/L	Jnclear	L	Part Lost/Mi	ssing	Wrong Stock Pulled	t
	Cuffs				Contamii	nation		/lainte	nance		∐f	Part Moved			
	Heat Trea	it			Counter	rsink		∕iislabe	eled			Positioned V	Vrong _	_	
	Inspection	n Strip in	Tube		Cut Too S	Short		⁄lisreac	i			Power Loss/	Surge	Other	
	Ripples in	Bend			Drill Hol	les		ffset					,		
	Torque W	/aves in E	Extrusion		Drawing	5	Пс	ot of C	Calibration						
	Turning S	equence			Finish			ot of S	Sequence						
	Wave/Twist in Tube				Folio	1 <del>-</del>			Outside Dimensions						

DQA:

Date:

#### **Picklist Print**

April-18-13 1:23:55 PM

Work Order ID: 100170

D3913-041

\*100170\*

Parent Item:

Parent Item Name: Long Basket Base Assemby. 350

\*D3913-041\*

**Start Date: 4/18/13** 

Required Date: 5/02/13

Start Qty: 1.00

Required Qty: 1.00

D4016-1 \*D4016-1\*

Hinge Half, Base

Manufactured

100 Each 52.0000

B97664 -3, \$13.05.06 Location Loc Qty Loc Code ST044 17 99098 17 WA 24 97664 24 WA005 11 94481 11 100 Each 6.0000

\*D4017-7\*

Manufactured

\*\*

B94149 JU13.05.06

**Location** Loc Qty Loc Code WA004 2 95102 WA005 69730 82969 85435 88392 100 Each 9.0000

D4017-9

D4017-7

Manufactured

No

\*\*

Location Loc Oty Loc Code WA004 6 95203 6 WA005 3 70341 81445

\*D4017-9\*

Rib

April-18-13 1:23:55 PM

**Shop Packet Print** 

Page 4

											DQA:	Date	:	
NCR: Y	es / No				WOR	ORDER NON-C	CON	FORN	/ANCE / UPE	DATE	QA Closed:	Date	:	
Work Orde	r.					DISPOSITION			Over the second	AGAINST DE	EPARTMENT/PROCESS			
Part No.  NCR No.				Wo	Rework Skid-tube Crosstube  Scrap Machining Small Fab  Use-as-is Thermoforming Finishing  ork Order Update Large Fab Composite			4	Water Jet  J. Eng. Coor.  e/Packaging  Supplier	Engineering Quality Other				
Root				Descri	ption of w	vork order update	ln	itial	Act	ion	Şign &			
Cause	Date	Step	Qty		or Non-co	nformance	Chie	ef Eng	Descr	iption	Date	Verification	QC Inspector	
Doc/Data								İ						
quip/Tooling		]												
Operator				1										
Material							1							
Setup		-												
Other					-									
Process		ļ												
Supplier			ĺ											
Training					1.									
Unapproved		<u> </u>	<u> </u>		<u> </u>		1		CODY		<u> </u>			
					1.		AULI	CATE	JURY					
Landin F	ng Gear			_	Bend	General		Grain			Ovalized		Pressure/Forced	
	Bending	-1.6		0/5	BOM/Ro	vuto		araiii Hardwa	ro	-	Over/Under	tolerance	Temperature/Cure	
-	Centre No Cracks	ot conce	ntric to	<sup>0/3</sup>  -	<b>⊣</b> 1	Damaged			on Incomplete	ļ	Part Incorred	<u> </u>	Weld	
ŀ	Crushed/	Crimpod		-	Burrs	Damageu	$\vdash$		ions incomplete/L	Inclear	Part Lost/Mi	<del> </del>	Wrong Stock Pulled	
}	Cuffs	crimped.		-	Contamir	nation	-	Mainte	·		Part Moved			
-	Heat Trea	at		<u> </u>	Counter		$\vdash$	Mislabe		-	Positioned V	Vrong		
}	Inspectio		Tube	-	Cut Too S		-	Misread		-	Power Loss/	_	Other	
}	Ripples in		1420		Drill Hol		-	Offset		. L	<u> </u>	~ <u>L</u>		
ŀ	Torque W		Extrusio	n	Drawing				Calibration					
T T	Turning S				Finish		$\vdash$	Out of Sequence						
	Wave/Twist in Tube Folio						Outside Dimensions							

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

April-18-13 1:23:55 PM

**Work Order ID:** 100170

\*100170\*

Parent Item:

D3913-041

\*D3913-041\*

Parent Item Name: Long Basket Base Assemby, 350

**Start Date: 4/18/13** 

Required Date: 5/02/13

Start Qty: 1.00

\*\*

Required Qty: 1.00

D4020-11

Manufactured

Manufactured

Manufactured

100

Each

11.0000

B.100650 - 2x Sy 13.05.06

\*D4020-11\*

End Mesh, Basket

Location Loc Qty Loc Code WA007 11 81442 2 84972 94553 97684 100 Each

\*\*

D4021-1

\*D4021-1\*

Handle Plate

D4034-041

29.0000

B& 89204 > 31 13.05.06

Location Loc Oty Loc Code WA004 29 89204 9 94596 3 95039 14 97940 2 98356 100 Each 4.0000

\*\*

Aft Upper Rib Assembly

Location Loc Qty WA005 84048 93187

Loc Code

NCR:													
										QA Closed:	Date:	Programme and the second secon	
Work Orde	ar.					DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Work Orac				<del></del>		Rework	7 <b>I</b>	Skid-tube	Crosstube		Water Jet	Engineering	
Part N	No.					Scrap	Machining Small Fab Prod. Eng. Coor. Qu				Quality		
						Use-as-is	The	moforming	Finishing	Rec/Sto	re/Packaging	Other	
NCR No.				٧	/ork Order Update	]	Large Fab	Composite		Supplier			
. D = -4		T	T	Doccri	ntion of	work order update	Initial	Τ	action	Sign &			
Root	Date	Step	Qty		•	conformance	Chief En		scription	Date	Verification	QC Inspector	
Cause Doc/Data	Date	Step	Qty		OI NOII-	·	Criici En	5	ocrip don	Date			
Equip/Tooling													
Operator		ŀ											
Material									,				
Setup						·							
Other													
Process			.										
Supplier							-						
Training		-								•			
Unapproved		<u> </u>								<u> </u>	<u> </u>		
					-		AULT CAT	EGORY					
Landi	ng Gear			_	ا، ۱۰	General			_	]		Pressure/Forced	
	Bending				Bend	<b>.</b> .	Grain		<u> </u>	Ovalized		Temperature/Cure	
	<del></del>	ot Conce	ntric to (	D/S  -	BOM		Hardv			Over/Under	<del></del>	We'ld	
	Cracks	<b>1</b> 0 '		-	- 1	n/Damaged	_	ction Incomplete	-///	Part Incorre Part Lost/M	<u> </u>	Wrong Stock Pulled	
	Crushed/	Crimped		-	Burrs	-imatian		ctions Incomplete tenance	e/Unclear —	Part Moved		I wrong stock runed	
	Cuffs	-4		-	<b>-1</b> 1	nination	Misla		-	Positioned \			
	Heat Tre		Tuba	-	Count		Misre		.  -	Power Loss,		Other	
	Inspection		rube	-	Drill H		Offse		<u> </u>	Trower ross	Juige	Tomer	
	Ripples in		<b>.</b>	. <b>-</b>	- 1		<b>—</b>	f Calibration					
	<b>⊢</b> ⊸l '	Vaves in E		` <del> </del> -	Drawii	ıg	<b>-</b>						
	⊢ -	Sequence		-	Finish Folio		<del>                                      </del>	f Sequence					
	Wave/Twist in Tube						Outsi	de Dimensions					

DQA: Date:

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

April-18-13 1:23:55 PM

Work Order ID: 100170

D3913-041

\*100170\* \*D3913-041\*

Parent Item:

Parent Item Name: Long Basket Base Assemby, 350

**Start Date: 4/18/13** 

Required Date: 5/02/13

Start Qty: 1.00

Required Qty: 1.00

D4034-043

D4672-1

Manufactured

No

100

Each

Loc Qty

5

2

3

sf

15.96

Each

5.0000

B 100286 SS 13.05.06

Fwd Upper Rib Assembly

Location WA005 82980 94490

100

16.0000

Loc Code

\*\*

Blanking Plate

Manufactured No

No

Location Loc Oty

WA005 16 88253 6 94551 10

596.0191

Loc Code

33 33

Purchased \*M304FX0 75-16F\*

Expanded Metal Flat SS

M304EX0.75-16F

Location Loc Qty Loc Code MAT

100

516.0591180 125113 516.059118 WA 64 124466 64 WA007 15.96

123448

\*\*

SJ13.05.06

es / Ni	)			WORK	DQA:Date: WORK ORDER NON-CONFORMANCE / UPDATE							:
<i>cs</i> ,										QA Closed:	Date	
er:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part No					Rework Scrap Use-as-is ork Order Update		Machining Small Fab Thermoforming Finishing		Crosstube Small Fab Finishing Composite	Rec/Store/Packaging		Engineering Quality Other
			Descri	ption of w	ork order update	In	nitial	Ac	tion	Sign &		
Date	Step	Qty		or Non-co	nformance	Chi	ef Eng	Desc	ription	Date	Verification	QC Inspector
					F	AULT	CATE	GORY				
Centre Not Concentric to O/S Cracks Broke Crushed/Crimped Cuffs Conta Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion Turning Sequence Finish			Bend BOM/Ro Broken/I Burrs Contamin Counters Cut Too S Drill Hole Drawing	Damaged lation sink hort es	Grain  Hardware  Inspection Incomplete  Instructions Incomplete/Unclear  Maintenance  Mislabeled  Misread  Offset  Out of Calibration  Out of Sequence				Part Incorre Part Lost/M Part Moved Positioned V	ct issing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled  Other	
	ng Gear Bendin Centre Cracks Crushe Cuffs Heat Ti Inspect Ripples Torque Turnin	Date Step  Date Step	Date Step Qty  Date Step Qty  Date Step Oty  Bending Centre Not Concentric to C Cracks Crushed/Crimped. Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion	Price Step Qty Description Turning Sequence Date Step Qty Control Description Turning Sequence	Description of work or Non-co  Date Step Qty or Non-co  Date Step Qty or Non-co  Bending Bend Bend Bom/Ro  Centre Not Concentric to O/S BOM/Ro  Cracks Broken/I  Crushed/Crimped Burrs  Cuffs Contamin  Cuffs Contamin  Heat Treat Counters  Inspection Strip in Tube Cut Too S  Ripples in Bend Drill Hold  Torque Waves in Extrusion Drawing  Turning Sequence Finish	DISPOSITION  Rework Scrap Use-as-is Work Order Update  Date Step Qty Description of work order update or Non-conformance  Date Step Qty Or Non-conformance  Fing Gear General  Bending Gentre Not Concentric to O/S BOM/Route  Cracks Broken/Damaged  Crushed/Crimped Burrs  Cuffs Contamination  Cuffs Countersink  Inspection Strip in Tube Ripples in Bend Drill Holes  Torque Waves in Extrusion Turning Sequence  DISPOSITION  Rework Scrap Use-as-is Work Order update  or Non-conformance  Fundamental Bend Contamination  Countersink  Cut Too Short  Drawing Finish	Pr:	Prime Prime	Paris   Disposition   Rework   Skid-tube   Machining   Thermoforming   Large Fab   Disposition   Disposition   Large Fab   Disposition   Dispo	Principle of the property of t	WORK ORDER NON-CONFORMANCE / UPDATE  QA Closed:  DISPOSITION  Rework   Skid-tube   Crosstube   Small Fab   Pro   Rec/Stot   Composite   Co	WORK ORDER NON-CONFORMANCE / UPDATE  OA Closed: Date  DISPOSITION  Rework Scrap  OBJECT SCREE

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## **Picklist Print**

April-18-13 1:23:55 PM

**Work Order ID:** 100170

D3913-041

\*100170\* \*D3913-041\*

Purchased

Manufactured

Manufactured

Parent Item:

AN3-10A

Washer D2931

Bumper

D4021-5

Parent Item Name: Long Basket Base Assemby, 350

**Start Date: 4/18/13** 

Loc Code

Each

Loc Qty

37

37

41

3

38

Required Date: 5/02/13

Start Qty: 1.00

Required Qty: 1.00

166.0000 \*\*

\*AN3-10A\*

AN960JD8	NAS1149DN832 J	Purchased	No
*AN960.	ID8*		

	ST351
	ST512
No	
No	

No

Location

Location

46064

86435

GA

ST021

122800

124221

124858

GA

12280	0	88 88				
	150	Each	0.0000			
	150	Each	2,216.00			

150

Loc Qty

218

218

1998

1998

Each

150

**	123348 gB
2,216.000 2 **	<sup>2</sup>
Loc Code	,

2

\*\*

20.0000

Loc Code

2	
<del></del>	
,	•
46064	
2 ~	
	13-05-08

\*D4021-5\* Blanking Plate

\*D2931\*

Location	Loc Qty
ST084	20
85065	2
89059	8
97893	10

97893

											DQA:	Date:	:
NCR: Y	es / No				WORK	ORDER NON-C	ONF	ORN	MANCE / UPDATE		- QA Closed:	Date	:
Maria Conda				· · · · · ·		DISPOSITION			AGA		PARTMENT/	PROCESS	
Work Order: Part No NCR No.					Wo	Scrap Machining Sm Use-as-is Thermoforming Fi			Machining Sma	stube III Fab III shing III sosite	Fab Prod. Eng. Coor. Quality ning Rec/Store/Packaging Other		
						` L							
Root Cause	Date	Step	Qty		-	ork order update	Init Chief		Action Description		Sign & Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other								5	·		·		
Supplier Training Unapproved				,									
						F	AULT	CATE	GORY				
Landir	ng Gear Bending				Bend	General	ПG	rain			Ovalized		Pressure/Forced
	Centre Not Concentric to O/S BOM/Cracks Broker Crushed/Crimped.				BOM/Ro Broken/I	Damaged	H:	Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance			Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved		Temperature/Cure Weld Wrong Stock Pulled
	Heat Trea	Heat Treat Countersink Inspection Strip in Tube Cut Too Short				sink hort	Шм	1islabe 1isread			Positioned V Power Loss/	Other	
	Ripples ir Torque V	Vaves in E		n	Drill Hole		$\Box$ $\circ$		Calibration				
	Turning S Wave/Tw				Finish Folio			Out of Sequence Outside Dimensions					

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April-18-13 1:23:55 PM

Work Order ID: 100170

Parent Item:

D3913-041

Parent Item Name: Long Basket Base Assemby, 350

MS20600-AD4W3

Purchased

No

No

Purchased

\*MS20600-AD4W3\*

Cherry Rivets

MS21042L3

\*100170\* \*D3913-041\*

150

**Start Date:** 4/18/13

Start Qty: 1.00

\*\*

\*\*

1,319.000

Required Date: 5/02/13

Required Qty: 1.00

Location Loc Qty Loc Code ST311 1186 122151 122452 123525 294 124231 884 124731 WA003 133 107939 133 150 Each 4,735.000

Each

\*MS21042L3\*

Location Loc Qty Loc Code FP001 3 122141 3 GA 110 122452 110 ST314 268 117885 32 119017 55 119075 138 123265 43 ST506 4354

974

3380

123900

124291

13-05-08

											DQA:	Date:	
NCR: Y	es / No				WORK	ORDER NON-C	CONF	ORN	MANCE / UPDA		- ۲۰۰۰	Data	
<del></del>	N			WORK ORDER NON-CONFORMANCE / UPDATE    DISPOSITION									
Mode Ordon					DISPOSITION				AGAINST DE	PARTMENT/	PROCESS		
Work Orde				<del></del>		Rework	7 <b> </b>		Skid-tuhe	Crosstube		Water Jet	Engineering
Part N	0					<del> </del>	1 1	[					T I
rait ivo.						·	1 <b> </b> -		×Щ			- j	ا → ن
NCR N	0.				Wol	<b>├</b>	1			~ <del> </del>		Supplier	
Root						· · · · · · · · · · · · · · · · · · ·	1	i i					
Cause	Date	Step	Qty	(	or Non-co	nformance	Chie	f Eng	Descript	ion	Date	Verification	QC Inspector
Doc/Data											}		
Equip/Tooling													
Operator	_	1											
Material	_						İ	İ					
Setup	-												
Other	-												
Process Supplier	$\dashv$	1											
Training	$\dashv$												
Unapproved	_												
1	<del> </del>	1				F.	AULT	CATE	GORY				
Landin	g Gear		•			General					-		_
	Bending				Bend		G	rain			Ovalized		<del> </del>
	Centre N	ot Conce	ntric to	o/s	BOM/Ro	BOM/Route		Hardware			Over/Under tolerance		<del></del>
	Cracks				Broken/Damaged			Inspection Incomplete			Part Incorrect		<b>-</b>
	Crushed/	Crimped			Burrs	Burrs		Instructions Incomplete/Unclear		lear	Part Lost/Missing		Wrong Stock Pulled
	Cuffs				Contamination		<del></del> }	Maintenance			-}		
	Heat Trea	at			-4		$\square^{\vee}$	Mislabeled			Positioned Wrong		$\neg$
	Inspectio		Tube		- i		<b></b>	Misread			Power Loss/	Surge	Other
	Ripples ir	n Bend			-1 1	es	$\vdash$	Offset					
	Torque W	Vaves in E	Extrusio	n	Drawing		<b>—</b>						
	Turning S				Finish		<b>—</b>						
	Wave/Tw	vist in Tul	be	i	FAULT CATEGORY  General  Bend Grain Ovalized Pressure/Forced  Hardware Over/Under tolerance Temperature/Cure  Broken/Damaged Inspection Incomplete Part Incorrect Weld  Instructions Incomplete/Unclear Part Lost/Missing Wrong Stock Pulled  Contamination Maintenance Part Moved  Countersink Mislabeled Positioned Wrong  Cut Too Short Misread Power Loss/Surge Other  Drawing Out of Calibration								

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April-18-13 1:23:55 PM

Work Order ID: 100170

Parent Item:

D3913-041

Parent Item Name: Long Basket Base Assemby. 350

NAS1149F0332P

Purchased

No

\*NAS1149F0332P\*

WASHER

\*100170\* \*D3913-041\*

**Start Date:** 4/18/13

Start Qty: 1.00

8,690.000

12 12

\*\*

Required Date: 5/02/13

Required Qty: 1.00

13-05-08

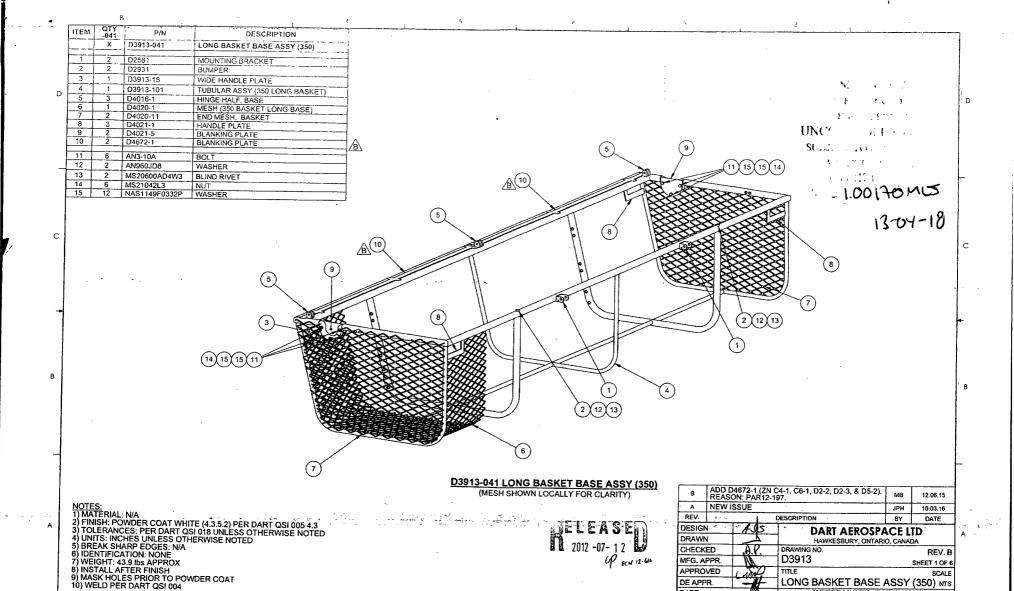
Location	Loc Qty	Loc Code	
GA	182		
122063	182		
ST294	158		
122063	158		
ST295	3		
123352	3		
st510	8347		
123900	8347		123900

Each

150

es / No			w	ORK ORDER NON-G	CON	FORM	MANCE / UP	DATE	DQA:	Date	:
r:		·		DISPOSITION				AGAINST DE	PARTMENT	_	
0			Rework Scrap Use-as-is Work Order Update		f Therm	Machining	Crosstube Small Fab Finishing Composite	4	d. Eng. Coor.	Engineering Quality Other	
	<u> </u>		Description	of work order update	i				Sign &		
Date	Step	Qty	or No	n-conformance	Chi	ef Eng	Desc	ription	Date	Verification	QC Inspector
					AUL	CATE	GORY				
Bending Centre No Cracks Crushed/ Cuffs Heat Trea Inspectio Ripples in	Crimped. at n Strip in n Bend Vaves in E	Tube	D/S BOM Brol Burr Cont Cou Cut Drill	d/Route ken/Damaged s tamination ntersink Too Short I Holes		Hardwa Inspecti Instruct Mainte Mislabe Misread Offset Out of (	ion Incomplete ions Incomplete, enance eled d	/Unclear	Part Incorre Part Lost/M Part Moved Positioned \	ct issing	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled  Other
			Foli	o <mark>l</mark>		Outside	Dimensions				
	r:	r:  O.  Date Step  Date Step  Bending Centre Not Concer Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Ripples in Bend Torque Waves in E	ng Gear Bending Centre Not Concentric to C Cracks Crushed/Crimped. Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend	r:	DISPOSITION  Rework Scrap Use-as-is Work Order Update  Date Step Qty  Description of work order update or Non-conformance  Fig Gear Bending Centre Not Concentric to O/S Cracks Crushed/Crimped. Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion Turning Sequence  Disposition Rework Scrap Use-as-is Work Order Update or Non-conformance  Figear  General Bend Bend BoM/Route Broken/Damaged Burrs Countersink Cut Too Short Drill Holes Drawing Finish	Table 1    Content   Conte	Therm    Disposition   Rework   Scrap   Use-as-is   Use-as-is   Therm   Date   Step   Qty   Description of work order update   Initial   Chief Eng	T: DISPOSITION  Rework   Skid-tube   Machining   Thermoforming   Large Fab    Date   Step   Qty   Description of work order update   Initial   Accepted   Chief Eng   Description of work order update   Chief Eng   Description of work order update   Initial   Chief Eng   Description of work order update   Chief Eng   Description of work order update   Chief Eng   Description of work order update   Chief Eng   Description of work order update   Chief Eng   Description of work order update   Chief Eng   Description of work order update   Chief Eng   Description of work order update   Chief Eng   Description of work order update   Chief Eng   Description of work order update   Chief Eng   Description of work order update   Chief Eng   Description of Work order update   Chief Eng   Description of Work order update   Chief Eng   Description of Work order update   Chief Eng   Description of Work order update   Chief Eng   Description of Work order update   Chief Eng   Description of Work order update   Chief Eng   Description of Work order update   Chief Eng   Description of Work order update   Chief Eng   Description of Work order update   Chief Eng   Description of Work order update   Chief Eng   Description of Work order update   Chief Eng   Description of Work order update   Chief Eng   Description of Work order update   Chief Eng   Description of Work order update   Chief Eng   Description of Work order update   Chief Eng   Description of Work order update   Chief Eng   Description of Work order update   Chief Eng   Description of Work order update   Chief Eng   Description of Work order update   Chief Eng   Description order update   Chief Eng   Description order update   Chief Eng   Description order update   Chief Eng   Description order update   Chief Eng   Chief Eng   Description order update   Chief Eng   Description order update   Chief Eng   Description order update   Chief Eng   Description order update   Chief Eng   Description order update   Chief Eng   Description order update   Chief Eng   Description	Part	PAULT CATEGORY  Gear  Bending Centre Not Concentric to O/S Caracks Cracks  See   No   WORK ORDER NON-CONFORMANCE   UPDATE	

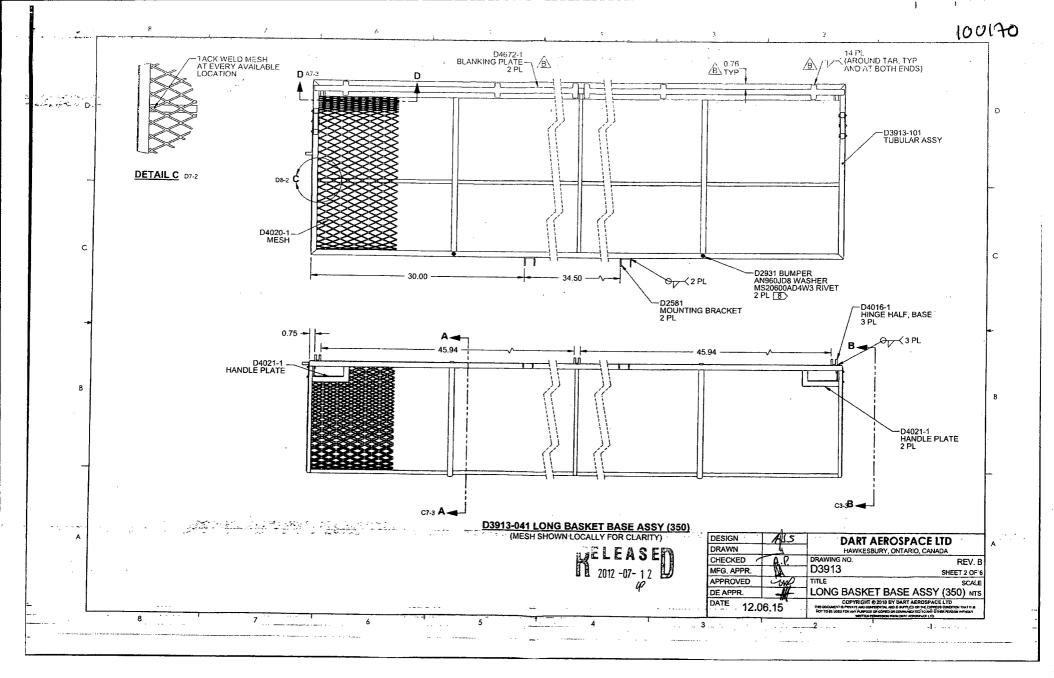
H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

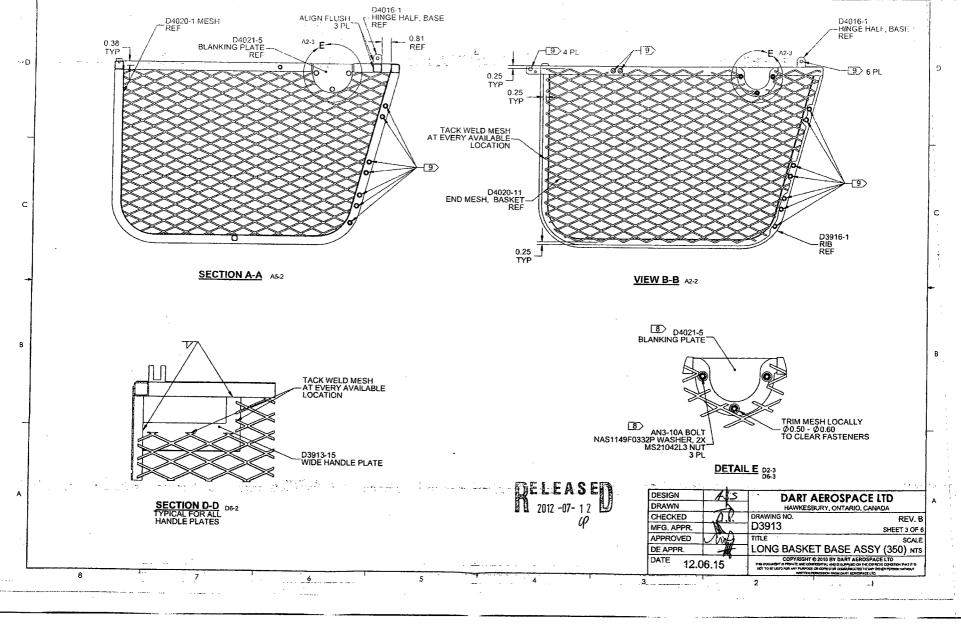


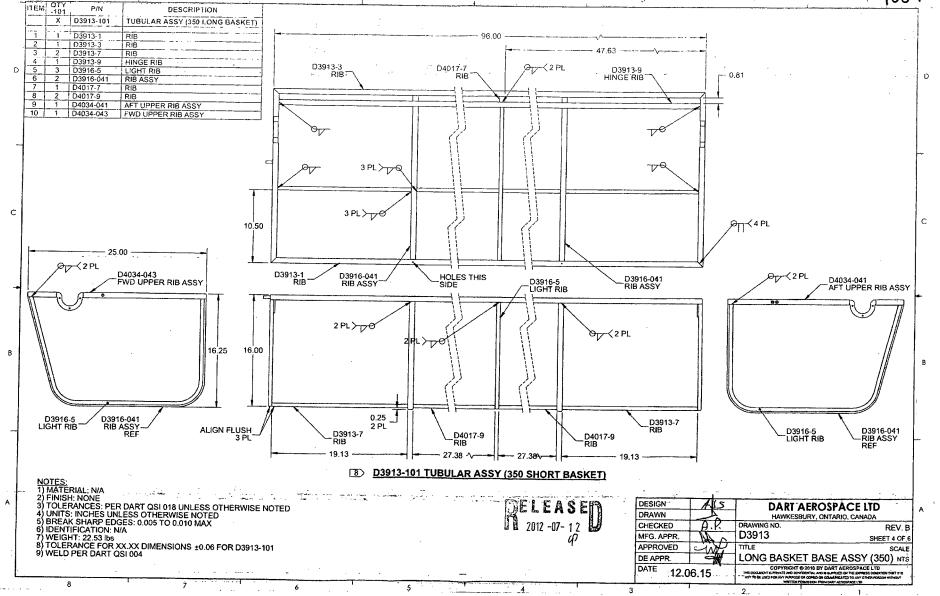
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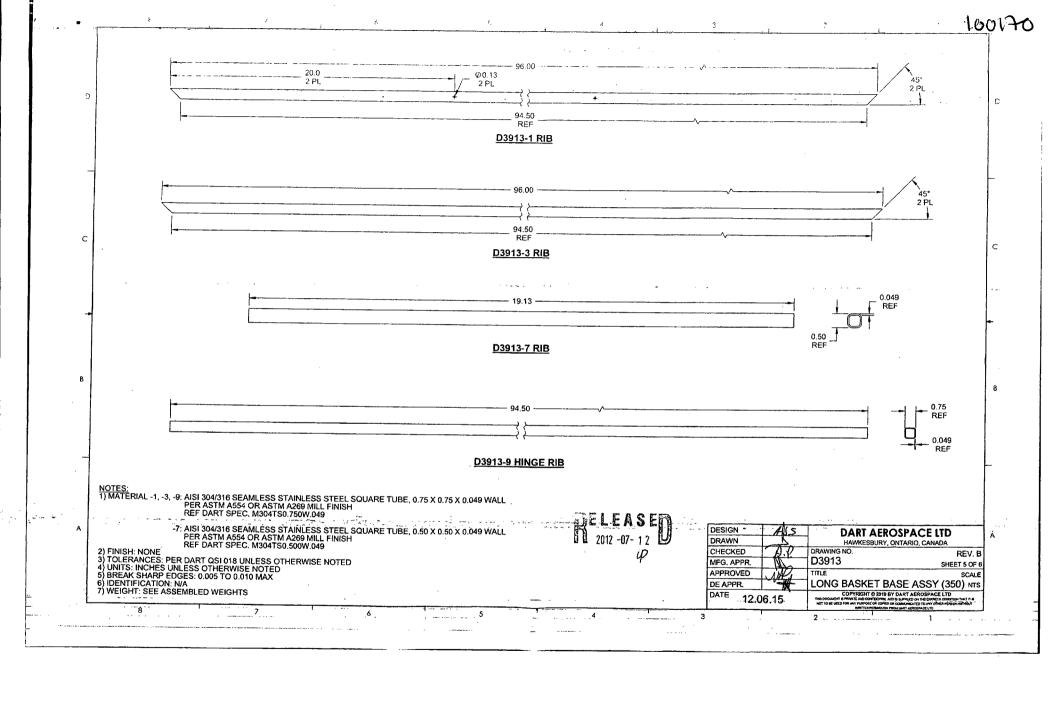
DATE

12.06.15

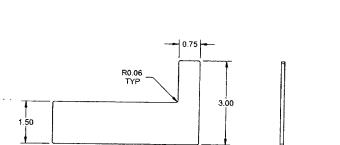












**D3913-15 WIDE HANDLE PLATE** 

NOTES:
1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA

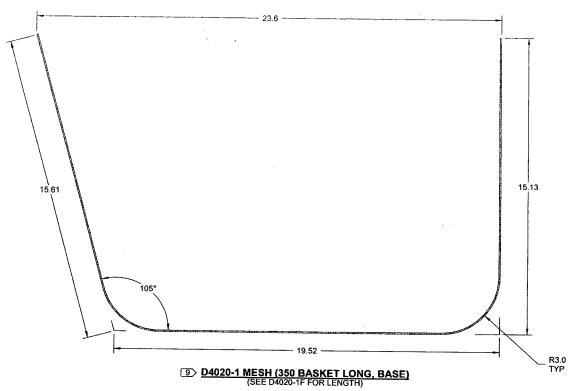
REF DART SPEC M304S11GA
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.31 lbs

P

DESIGN \* DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWN CHECKED DRAWING NO. REV. B D3913 MFG. APPR. SHEET 6 OF 6 TITLE APPROVED SCALE LONG BASKET BASE ASSY (350) NTS

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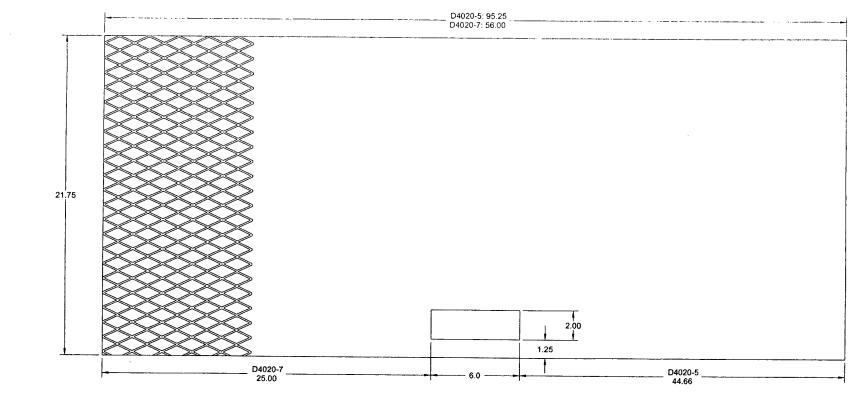
9 <u>D4020-3 (350 BASKET SHORT, BASE)</u> (SEE D4020-3F FOR LENGTH)

NOTES:
1) MATERIAL-1: MAKE FROM D4020-1F
-3: MAKE FROM D4020-3F
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: SEE D4020-1F & D4020-3F
8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS
9) PRE-FORMING OF MESH PER SHOP OPTION, THIS VIEW MAY BE USED FOR REF ONLY

D

A	NEW IS	SUE	T	JPH	10 03.04		
REV.			DESCRIPTION	BY	DATE		
DESIG	V	AJS	DART AEROSPA	CE	TD		
DRAWN .		JPH	HAWKESBURY, ONTARIO		1:		
CHECK	ED	a	DRAWING NO.		REV. A		
MFG. A	PPR.	80	D4020		SHEET 1 OF 4		
APPRO	VED	JW	TITLE		SCALE		
DE APPR.		-#	350 BASKET MESH (BASE) NT				
DATE	10.0	3.04	COPYRIGHT 9: 2010 BY DART AEROSPACE LTD  this occupient is strent who confidently, and is service to the confidency operation ryelf if is  not to be used for any furprise on cores on columbia. Date to the office received without  with the confidence of the confidence of the columbia.				

100170



D4020-5 MESH (350 BASKET LONG, LID)
 (LOCAL SECTION MESH SHOWN FOR CLARITY)

D4020-7 MESH (350 BASKET SHORT, LID)
 (LOCAL SECTION MESH SHOWN FOR CLARITY)

NOTES:  1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F REF DART SPEC. M304EX0.75-16F  (LOCAL SECTION MESH SHOWN FOR CLAF	, LID) RITY)
2) FINISH: NONE	DESIGN
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED 4) UNITS: INCHES UNLESS OTHERWISE NOTED	DRAWN
5) BREAK SHARP EDGES: N/A	CHECKED
6) IDENTIFICATION: N/A 7) WEIGHT -5: 0.80 lbs APPROX	MFG. APPR
-7: 4.49 lbs APPROX	APPROVED
8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS	DE APPR.
9) TOLERANCE ON XX.XX DIMENSIONS ± 0.06.	DATE

DESIGN	AJS					
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA				
CHECKED	9	DRAWING NO. REV	/. A			
MFG. APPR.	E	D4020 SHEET 20	OF 4			
APPROVED	JAP.	TITLE SC.	ALE			
DE APPR.	-#	350 BASKET MESH (BASE)	NTS			
DATE 10.0	3.04	COPYRIGHT © 2010 BY DART AEROSPACE LTD  THIS DOOLMENT IS PRIVATE AND CONFIDENTIAL AND IS REPULD ON THE COMPETS COMPTION THAT IT HOT TO BE USED FOR ANY PLAPOSE OR COMPLE OR COMMANISCATED TO ANY OTHER PERSON WITHOUT POWERS AND MART ADMISSIANCE LTD.  WITHTON POWERSOM PROMISE AND MART ADMISSIANCE LTD.				

0.40 REF 15.50 2.00 0.38 5.64 R3.38 8 2 PL 20.18 9 D4020-11 END MESH, BASKET

NOTES:
1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F
REF DART SPEC. M304EX0.75-16F
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: 1.22 Ibs

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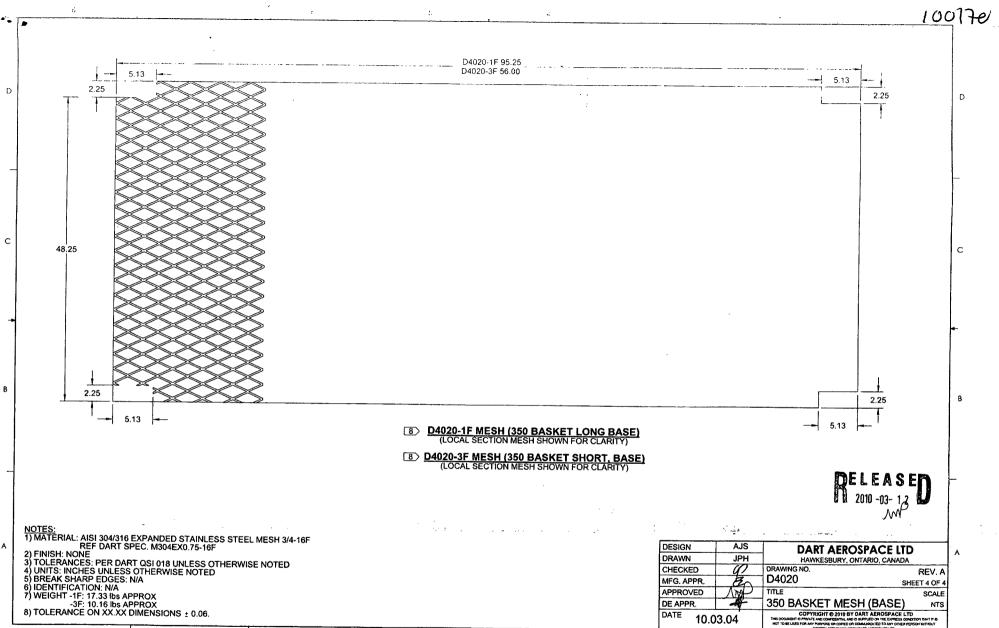
7) WEIGHT, 2003 8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS 9) TOLERANCE ON XX.XX DIMENSIONS  $\pm$  0.06.

DESIGN DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA AJS DRAWN JPH DRAWING NO. CHECKED REV. A D4020 MFG. APPR. SHEET 3 OF 4 APPROVED TITLE SCALE 350 BASKET MESH (BASE)

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DES DOOMSHOT OF WHATE ADD CONFEDURAL NOS SUPPLES ON THE EXPRESS ONTHE PROPERS OF THE EXPRESS ON THE EXPRESS DE APPR. NTS DATE 10.03.04

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DESIGN AJS		DART AEROSPACE LTD				
DRAWN JPH		HAWKESBURY, ONTARIO, CANADA				
CHECKED	9	DRAWING NO.	REV. A			
MFG. APPR.	En	D4020 SHE	ET 4 OF 4			
APPROVED	-VM	TITLE	SCALE			
DE APPR.	#	350 BASKET MESH (BASE)	NTS			
DATE 10.0	3.04	COPYRIGHT © 2016 BY DART AEROSPACE LTD THIS DODARD IS PRIVATE AND COMPIDENTIAL AND SUPPLED ON THE EXPRESS COMPITED THAT IT IS				